

Wednesday, 4/4/2007 9:05:46 AM
Kim Johnston

Process Sheet

Split. 200622

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31615 -2
Estimate Number : 10575
P.O. Number : N/A
This Issue : 4/4/2007 S.O. No. : N/A
Prelim Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 30842
Written By :
Checked & Approved By : J0204.04
Comment : Est Rev:B 05-10-14 Modified step 10 KJ/EC
Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294
JLM
Est Rev:C 06-06-27 Revised as per DSI9340 JLM

Drawing Name : SHORT STEP ASSEMBLY HIGH SKID LH
Part Number : D350591213
Drawing Number : D3078 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 4/30/2007 Qty: 10 Um: Each

Additional Product

Part Number



Seq. #

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-213 CHG002

2.0

D2622120C

Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2622-120C

Extrusion

B32194-1

B31954-2

B329601-1

A.M

07.06.19

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

R.M

07.06.19

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

U.M

07.06.19

3-Deburr

C.M

07.06.19

4.0

Q65

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12. 07.06.21

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 31615

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate 331653

JE 07-06-21 10

6.0

D30631

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support 330892

JE 07-06-21 10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072
A/R Aluminum Rod M102756

3-Grind End Plate flush

JE 07-06-21 10

JE 07-06-21 10

JE 07-06-21 10

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Morley

LA

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JE 06-21 10

POSITIVE
RECALL

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 07-06-21

10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 31615

Part Number: D350591213

Job Number:



Seq. # Machine Or Operation:

Description:

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Jan 21 @ 10



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy *331794*

PE. 07-06-21 10

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer *331834 = 15*

PE. 07-06-21 10

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet *MIC4156 = 15*

PE. 07-06-21 10

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

PE. 07-06-21 10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Jan 21 @ 10



POSITIVE
RECALL

Comment: INSPECT WORK TO CURRENT STEP

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate *331653*

PE. 07-06-21 10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 31615

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod M102756

4-Grind End Plate flush

Ph-07-06-21

10

Ph-07-06-21

10

Ph-07-06-21

10

*Ph-07-06-21-3**am*

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/06/22**(2)*

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8/2 Aug-22**(2)*

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

*M-L**07/06/22**(2x)*

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR/M-L 07-06-22**(2x)*

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

*M 104733**M-L**07/06/22**(2x)*

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

*Ph-7/6/22**(2)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 31615

Part Number: D350591213

Job Number:



Seq. # Machine Or Operation: Description:

25.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

26.0 D2182B Neoprene Cushion-750 bl



Comment: Qty.: 0.3000 f(s)/Unit Total: 3.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2182b035 Rubber Cushion

B30872 ✓

27.0 D2274 Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2274 Radius Block

B30875 ✓

28.0 D2732 Rubber Extrusion



Comment: Qty.: 1.0500 f(s)/Unit Total: 10.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2732-030(3" LONG)

Rubber Cushion

B26472 ✓

29.0 D2856400 Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip

B39020 ✓

30.0 D22301 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

B30992 ✓

7/6/22 S9

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 31615

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

31 0

D22303

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

M30993 ✓

32 0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

M104021 ✓

33 0

AN411A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A

Bolt

M102280 ✓

34 0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M104118 ✓

35 0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M103691 ✓

36 0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut

M103691 ✓

Halter SD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SH0RT STEP ASSEMBLY HIGH SKID LH

Job Number: 31615

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 MS21042L3

Nut (or -3)

37.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M102552 ✓

38.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Batch: M104118 ✓

7/6/2009

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/8/22 07/06/22 (2)

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-212

Location: C

PPP Rev: C

7/8/22 (2)

41.0

QC21

FINAL INSPECTION W/O RELEASE



(2)

Comment: FINAL INSPECTION W/O RELEASE

7/10/22

U 7.06.22

Job Completion:



POSITIVE RECALL

EFFECTIVE 7/6/21 AUTH U

RELEASED U DATE 7/10/22



RELEASED
02.01.20

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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NO. 31615

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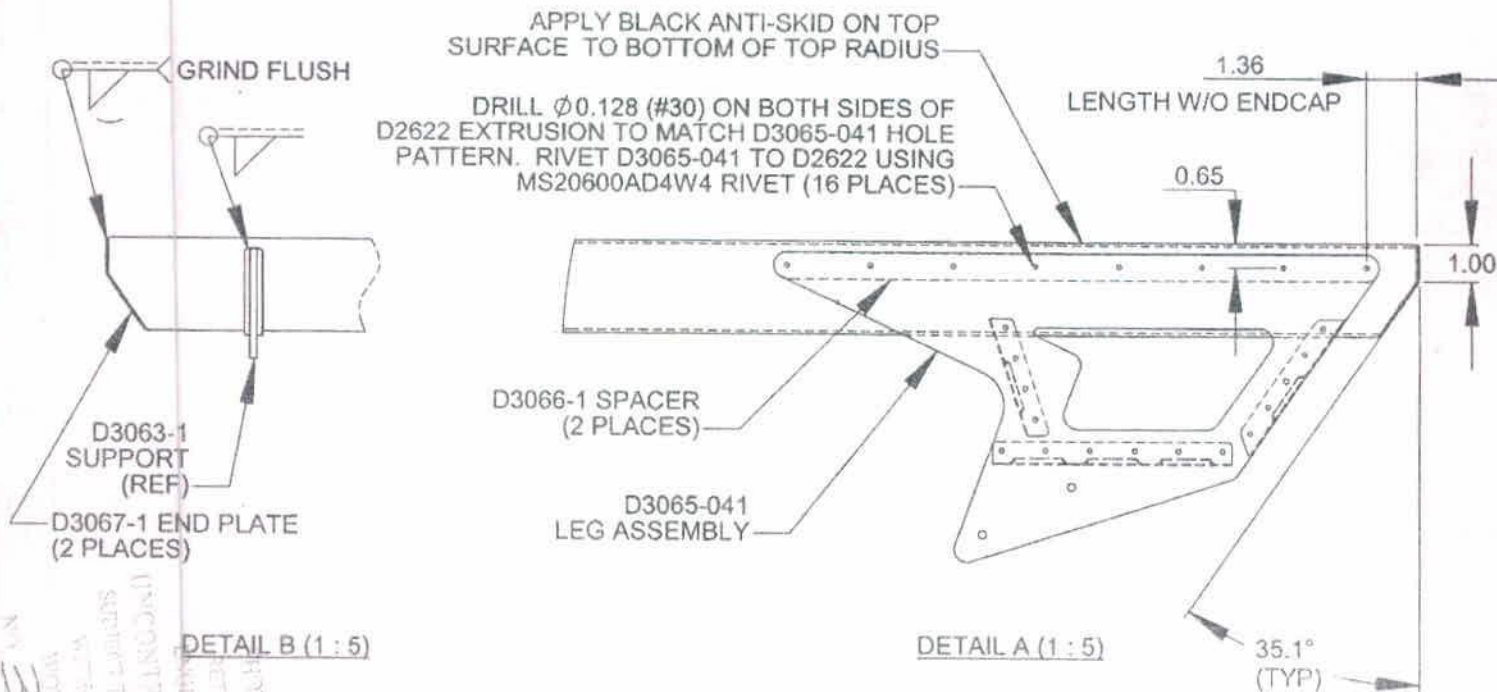
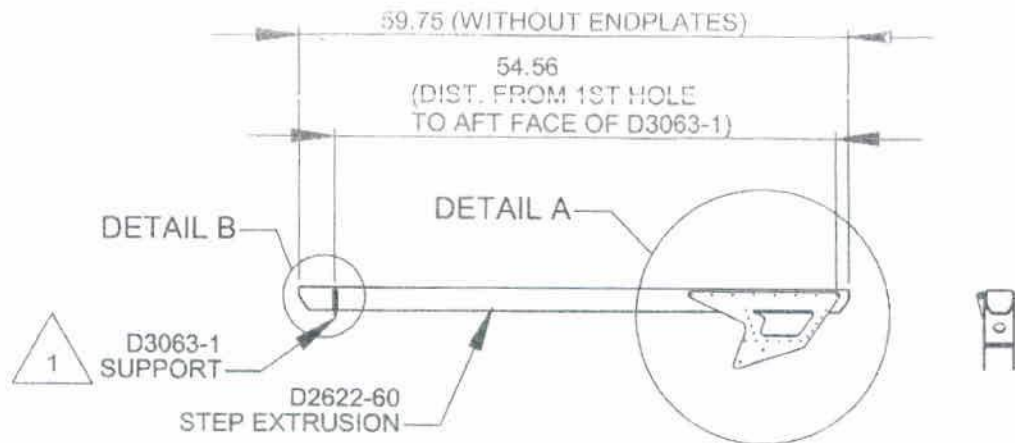
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. A
02.09.11		SHEET 2 OF 2
	TITLE	SCALE
	STEP ASSEMBLY, HI SHORT	1:20

RELEASED
02.09.2011



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SUPPORT TO MANAGEMENT
W-2011-00101
3/6/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-22	19.0	Split the order shipment. Qty 2 on this w/o 8 on original -1.	J	07-06-22	2	J 07-06-22	J 07-06-22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries